

20.80

Work Order ID 152749***152749***

Page 1

Monday, November 07, 2016 3:09:06 PM

Item ID: D2565-101 **Accept** ***N900040100*** **Setup** **Start** ***NS1***
Revision ID: **Stop** ***NS2***
Item Name: Strut
Start Date: 11/1/2016 **Start Qty:** 3.00 ***3*** **Cust Item ID:**
Required Date: 11/7/2016 **Req'd Qty:** 3.00 ***3*** **Customer:**
Reference:

Approvals: **Process Plan:** VS/DAS 21 9-89 **Date:** 16/11/8 **Tooling:** **Date:** **Run** **Start** ***NR1***
QC: **Date:** **SPC (Y/N):** **Date:** **Stop** ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2565	Rev E								
100	Punch ends and deburr as per dwg	0.00							
100	NC BRAKE								
Brake NC	Memo	0.06							
Brake NC	Punch as per Dwg D2565 using DT 8313								
110		0.00							
110	Small Fab								
Small Fab	Memo	0.07							
Small Fab	Drill hole open to .316 Ø as per Dwg D2565 (one end only)								
	Deburr								
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.01							
Quality Control									

3 Ø 17-1-3 DAS 19 9-89

3 Ø 17-1-3 DAS 19 9-89

3 17-01-03 DAS 9 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Work Order ID 152749

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152749

Page 2

Item ID: D2565-101 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Strut
Start Date: 11/1/2016 Start Qty: 3.00 ***3*** Cust Item ID:
Required Date: 11/7/2016 Req'd Qty: 3.00 ***3*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel <i>M 136113.</i> Memo START TIME: <i>11:10.</i> OVEN TEMPERATURE: <i>400°</i> FINISH TIME: <i>11:40.</i>	0.00 0.01				<i>3</i>	<i>0</i>	<i>17-01-04.</i>	<i>33</i> <i>9-89</i>
140 *140* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<i>3</i>			<i>DAS</i> <i>38</i> <i>9-89</i> JAN 09 2017
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: <i>5353</i> Memo	0.00 0.00				<i>3</i>			<i>JAN 11 2017</i> <i>DAS</i> <i>6</i> <i>9-89</i>

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
338		338		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____		

Work Order ID 152749

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152749

Page 3

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.05							
Quality Control									

DAS
21
9-89 JAN 16 2017

DAS
21
9-89 JAN 11 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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OTHER : _____																																																															

Picklist Print

Monday, November 07, 2016 3:09:06 PM

Work Order ID: 152749

152749

Parent Item: D2565-101

D2565-101

Parent Item Name: Strut

Start Date: 11/1/2016

Required Date: 11/7/2016

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP: F02.04.16Added dwg Rev.C1NG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.750W.049		Purchased			No	100	f	220.4210	1.71	5.4			
M304TR0 750W 049										**			
304 RD Tube .750 x .049W													

17-1-3
DAS
19
3-25

Location	Loc Qty	Loc Code
GA002	220.4209607	
M134528	30.2105266	
M134604	43.420524	
M134824	5.8478935	
M135093	33.68421	
M135242	36.2852715	
M135325	0.6571554	
M135373	39.983907	
M135709	5.1790537	
M135857	25.152419	

136323

5.4

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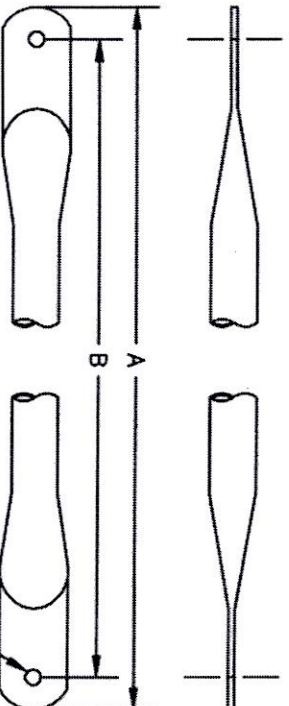
DART**DART AEROSPACE LTD**
HAWKESBURY, ONTARIO, CANADA

DESIGN	<i>[Signature]</i>	DRAWN BY	<i>[Signature]</i>	DRAWING NO.	REV. E
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	D2565	SHEET 1 OF 1

DATE	04.05.05	TITLE	STRUT	SCALE	1:3
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RELEASED
04.05.05

A	96.05.03	NEW ISSUE
B	97.03.15	CORRECT D2565-111 DIM. A
C	98.10.05	UPDATED MATERIAL NOTE (TSR A603)
D	02.06.05	ADD -3XX PARTS; ADD FINISH
E	04.05.05	ADD D2565-401-411; RMV ANGLE D



DIA 0.257 TO BE PUNCHED
"C" DIA TO BE OPENED MANUALLY

PUNCH ENDS PER SPEC CONTROL DRAWING D2638

PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	-
D2565-109	12.31	11.51	-
D2565-111	13.65	12.85	-
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	-
D2565-209	15.16	14.36	-
D2565-211	14.14	13.34	-
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	-
D2565-309	20.17	19.37	-
D2565-311	16.30	15.50	-
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	-
D2565-409	9.34	8.54	-
D2565-411	13.81	13.01	-

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ENGINEERING**UNCONTROLLED COPY**

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDERNO. 152749*1/6/02*
*16/4/8***GENERAL NOTES**

- 1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL
(REF. DART SPEC. M304TRO.750WO.049)
ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3} TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4} ALL DIMENSIONS ARE IN INCHES

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval			
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval			
Root Cause		FAULT CATEGORY									
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Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER :									
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